

Date: Friday, 02/05/2008 1:28:41 PM
User: Jean-Luc Menard

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : ARM
Job Number : 39005	
Estimate Number : 13294	
P.O. Number :	Part Number : D3696041
This Issue : 02/05/2008 S.O. No. :	Drawing Number : D3696 PROTO
Prsht Rev. : NC	Project Number : N/A 08.06.02
First Issue : 02/05/2008 Type : MACHINED PARTS	Drawing Revision : PROTO
Previous Run :	Material :
Written By : <i>[Signature]</i> 08.05.02	Due Date : 09/05/2008 Qty: <i>1</i> Um: Each
Checked & Approved By :	
Comment : Est Rev:A New Issue 08-05-01 JLM Verified By:EC	

Additional Product

FOR ENGINEER USE ONLY

PROTOTYPE

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M7075T6B1500X1500	7075 T6 BAR
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Comment: Qty.: 1.6666 f(s)/Unit Total: 6.6664 f(s)
7075 T6 BAR 1.5" x 1.5"
Batch: *M106368*

[Signature] 08.05.02 (1)

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW
Cut blank 19.750" long

[Signature] 08.05.02 (1)

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE
1- Mill as per dwg D3696
2-Deburr as per dwg D3696

[Signature] 08.05.02.01

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

[Signature] 08.05.02 (1)

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

[Signature] 08.05.02

6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

FL 08/05/06 (1)

Date: Friday, 02/05/2008 1:28:41 PM
User: Jean-Luc Menard

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 39005

Part Number: D3696041

Job Number:



Seq. #:

Machine Or Operation:

Description:

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

2 08/05/06 (80)

8.0

BNT137

Bronze Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Bronze Bushing

Batch: ~~M107881~~ M107881

Jul 08 05 00

9.0

PRT12

Arm Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

plunger

Batch: M107824

FF 08-05-20

10.0

MS21209C8 20

Heli Coil Insert



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Heli Coil Insert

Batch: M108066

FF 08-05-20

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Install Helicoil

2-Press BNT-137 Bushing

3-Install Plunger

FF 08-05-20

Jul 08.05.20

FF 08-05-20

12.0

QC5

ENGINEERING
APPROVAL

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08.05.20

13.0

PACKAGING 1

PACKAGING RESOURCE #1



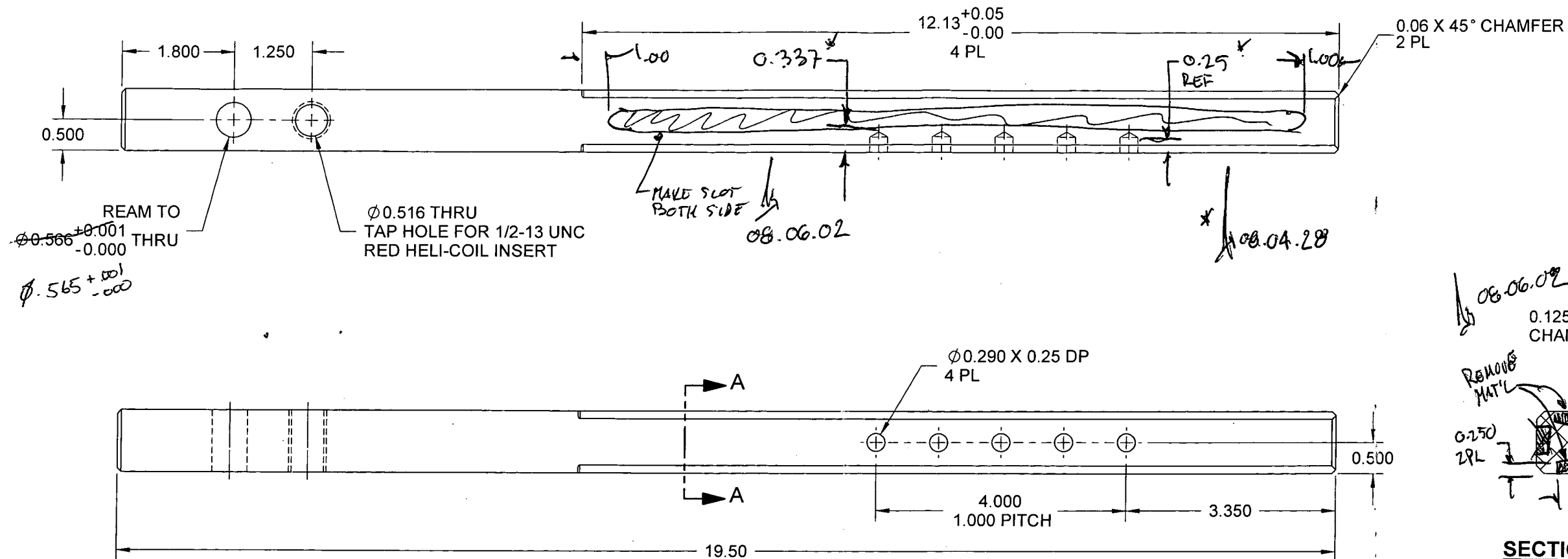
Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Not REQ'D

08.05.07



D3696-1 ARM

Batch: M106368

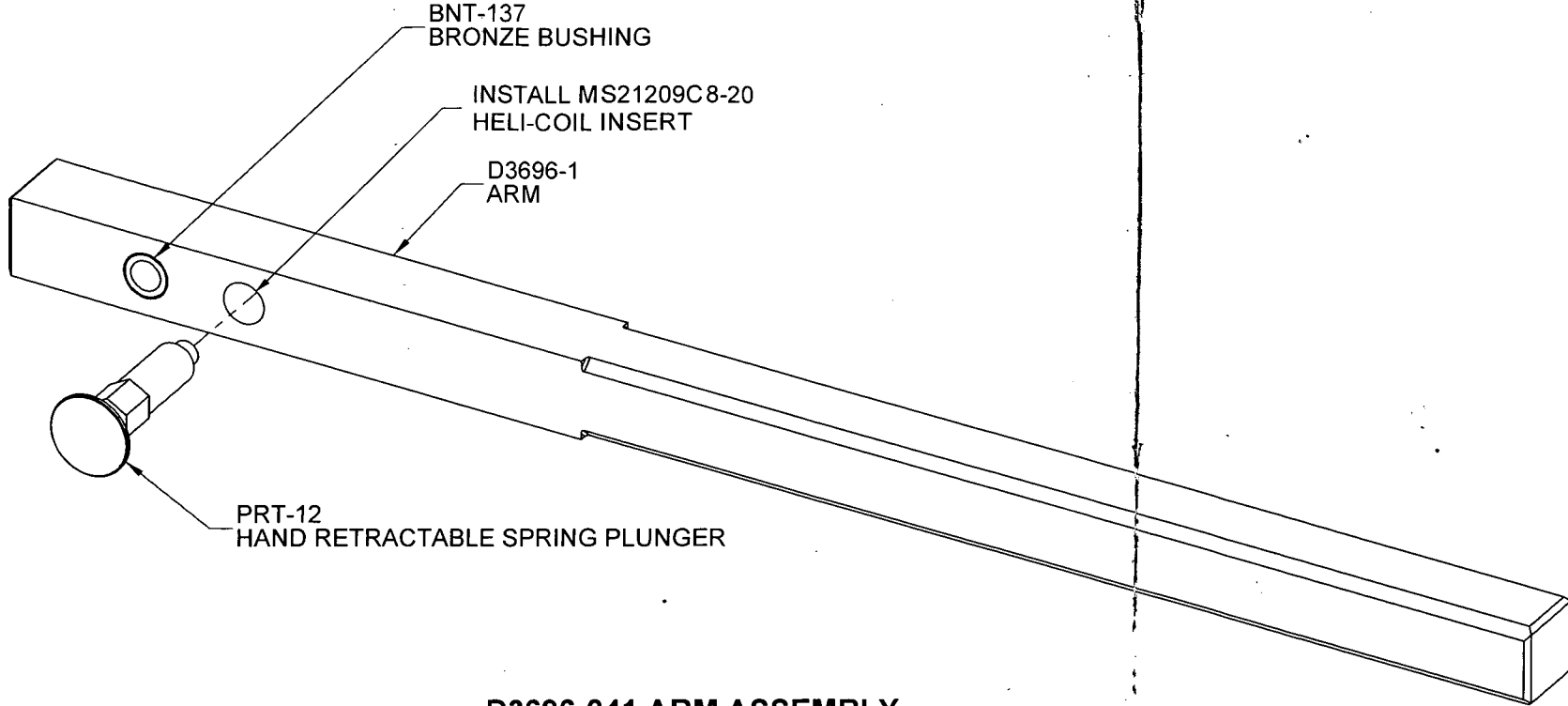
D3696-1 NOTES:

- 1) MATERIAL: 7075-T6 (OR T651/T6512/T6511/T62) ALUMINUM BAR PER AMS-QQ-A-229/9 (OR AMS 4122/4123/4186/4187) OR PER AMS-QQ-A-200/11 (REF. DART SPEC. M7075T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.87 lbs

PROTOTYPE
PLEASE RETURN ALL ISSUED
PRELIMINARY ISSUE
08.04.25

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3696	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		ARM	NTS
DATE	08.04.18	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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QTY -041	P/N	DESCRIPTION
X	D3696-041	ARM ASSEMBLY
1	D3696-1	ARM
1	BNT-137	BRONZE BUSHING
1	PRT-12	HAND RETRACTABLE SPRING PLUNGER
1	MS21209C8-20	HELI-COIL, SCREW LOCKING (RED)



D3696-041 ARM ASSEMBLY

PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING
PRELIMINARY ISSUE
08.04.25

- D3696-041 NOTES:**
1) MATERIAL: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3696-041" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 1.93 lbs

A	NEW ISSUE		MB	08.04.18
REV.		DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN				
CHECKED		DRAWING NO.	REV. A	
MFG. APPR.		D3696	SHEET 1 OF 2	
APPROVED		TITLE	SCALE	
DE APPR.		ARM ASSEMBLY	NTS	
DATE	08.04.18	COPYRIGHT © 2008 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>		

Date: Friday, 02/05/2008 1:28:41 PM
 User: Jean-Luc Menard

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 39005
 Estimate Number : 13294
 P.O. Number :
 This Issue : 02/05/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : 02/05/2008 Type : MACHINED PARTS
 Previous Run :
 Written By : *JLM 03.05.02*
 Checked & Approved By :
 Comment : Est Rev: A New Issue 08-05-01 JLM Verified By: EC

Drawing Name : ARM
 Part Number : D3696041
 Drawing Number : D3696 PROTO
 Project Number : N/A
 Drawing Revision : PROTO
 Material :
 Due Date : 09/05/2008 Qty: *1* Um: Each

PROTOTYPE

Additional Product

FOR ENGINEERING USE ONLY

Job Number:

Seq. #:

Machine Or Operation:

Description:

1.0

M7075T6B1500X1500

7075 T6 BAR

Comment: Qty.: 1.6666 f(s)/Unit Total: 6.6664 f(s)
 7075 T6 BAR 1.5" x 1.5"
 Batch: *M106368* *7/0.5018* *metux ceste*

2.0

BAND SAW

BAND SAW

Comment: BAND SAW
 Cut blank 19.750" long

3.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE

Comment: CONVENTIONAL MILLING MACHINE
 1- Mill as per dwg D3696

2-Deburr as per dwg D3696

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0

QC8

SECOND CHECK

Comment: SECOND CHECK

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1

Comment: HAND FINISHING RESOURCE #1
 Chemical Conversion Coat as per QSI 005 4.1

Certified Inspection Report

08/15/05
14:06:19

Alcoa Global Cold Finished Products
Massena Operations
Park Avenue East, Massena, NY 13662



Customer Yarde Metals	Customer P.O. No. P50624DK002	Customer Part No.	Alcoa Order No. MMC-63268- -007	Govt. Contract No.
Ship To Yarde Metals Old Pratt & Whitney Bld 4 Street Southington, CT 06489		We hereby certify that the material covered in this report has been inspected in accordance with, and has been found to meet the applicable requirements described herein, including any specifications forming a part of the description and that samples representative of the material met the composition limits and have the mechanical properties shown on the face of this sheet. Manufactured under an ISO/9000 registered quality management system. Meked and manufactured in the USA. James A. Brock, Quality Assurance Manager		
Date Shipped 08/15/05	Weight Shipped 1,542 lbs	Product CFRB-CF SQ	Specific Length	BOL 000151238
Alloy - Temper 7075-T651	Size 1.5000 IN	Shape SQ	Config 12 FT	QRR

Specifications:

AMS 4123G (Except Marking)
QQA-225/9E
AMS-QQA-225/9
ASTM B211-03
Material conforms to T6 requirements

Product produced and marked to the requirements of AMS-QQ-A-225/9 also meets the requirements of QQ-A-225/9.
Product produced and marked to the requirements of QQ-A-225/9 also meets the requirements of AMS-QQ-A-225/9.

YARDE METALS, INC. CERTIFIES THAT
THIS IS A TRUE COPY OF THE ORIGINAL
MILL TEST REPORT NOW ON FILE.
RECEIVED AND INSPECTED

TEST REQUIREMENTS		Test	Test	Test	Test	Test	Test	Test	Test
		U.T.S.	T.Y.S.	%Elong					
Max:									
Min:		77.0	66.0	07.0					

Test Results		Test	Test	Test	Test	Test	Test	Test	Test
		U.T.S.	T.Y.S.	%Elong					
Lot / Work Order	No. of Tests								
00500050982	1								
Max:		81.6	75.7	14.0					
Min:		81.6	75.7	14.0					

TEST ABBREVIATIONS

U.T.S. Ultimate Tensile Strength KSI T.Y.S. Tensile Yield Strength KSI %Elong Elongation % in 2"

Aluminum Association Chemical Composition Limits (in Weight %)

ALLOY	MAX	%SI	%FE	%CU	%MN	%MG	%CR	%ZN	%TI	%Others	%Others	%AL			
7075	MIN	0.40	0.50	2.0	0.30	2.9	0.28	6.1	0.20	0.05	0.15	Rem			
				1.2		2.1	0.18	5.1		Each	Total				

Actual Started Chemistry

LOT/WORK ORDER	MAX	%SI	%FE	%CU	%MN	%MG	%CR	%ZN	%TI	%OE	%OT	%AL			
00500050982	MIN	0.07	0.21	1.6	0.02	2.4	0.20	5.6	0.03	LT 0.05	LT 0.15	Rem			
		0.07	0.21	1.6	0.02	2.4	0.20	5.6	0.03						

NOTES:

31-559205



Based on documentation furnished to us by the mill / supplier, we certify this material to be free of mercury contamination.

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06 Dec 04	3.0	mill slots AS INDICATED on Dy.	<i>[Signature]</i>	06-06-04	①	<i>[Signature]</i> 06 Dec 04	<i>[Signature]</i> 06 Dec 04

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries